



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

13643

D5468-1

Job Sheet 193215



DAS
21
9-68

Part No: D5468-1

Job Qty: 10 pcs

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 13643

Due Date: 5/16/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	5/16/19		0.00	19.81	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 2	10 pcs	5/16/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

Sub 19/5/19

VHS 19/5/19



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S181759



Part: D5468-1

Job No: 193215

Serial No/Batch: S181759

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/16/19

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
130	QC 8	10	5/16/19	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
140	Handfinish - 1-1 Chemical-B4B	10	5/16/19	0.00 1.40	Handfinish - 1 - 1 - B4B
		pcs			Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B

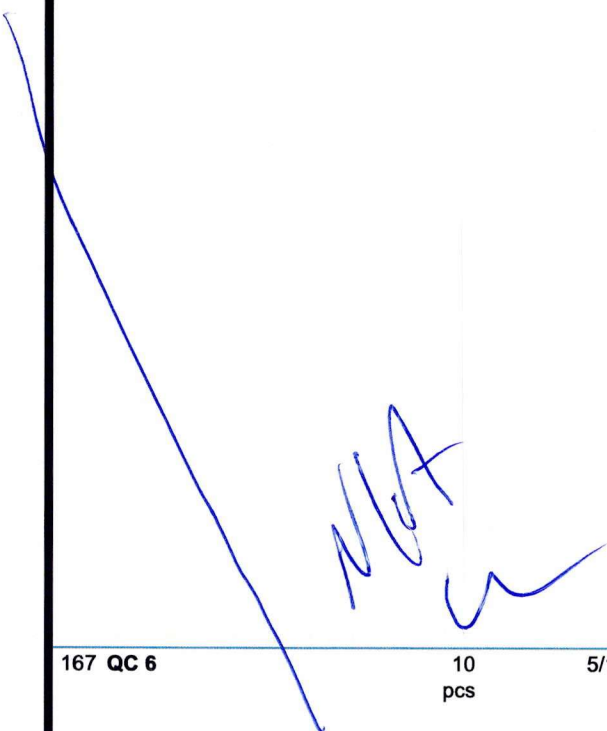
Same 19/05/19 ✓

★ MAY 22 2019

					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	10 pcs	5/16/19	0.00 0.25	Spray Paint - 1 - B4B	RD 19-5-25
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 14	10 pcs	5/16/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	MAY 29 2019 40
					QC 14 - 19	9-89
163	Outsource - 11 - Paint	10 pcs	5/16/19		ATE003-VC	2
165	Packaging 2-1 - Receive - B4B	10 pcs	5/16/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	

N/A

More can

					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	
167 QC 6	10 pcs	5/16/19	0.00	0.00	QC 6 - 68	
					QC 6 - 61	
170 Packaging 3-1 - Stock - B4B	10 pcs	5/16/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 -	

DAS
28
9-89

				B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	10 pcs	5/16/19	0.00 0.00	QC 21 - SA - 21	DAS 21 JUN 04 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. 518759 Double check by: SL 1-Machine Step No 1 per Descriptions: Folio FB548 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5163577 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: 5179047

160 - (QC14- Inspect Spray Paint)

163 - ISSUE P/O: _____ ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 8*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____ C OF C IS REQUIRED

165 - (Receive & Inspect for Damage & Mat'l Certs)

167 - (QC6- All purchased or subcontracted products)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	10 pcs (1 ea)	100-HAAS 4 Axis	<u>5175543</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-007	10	59	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD	Work Order: 546 193215
Description: Saddle, Aft Inboard	Part Number: D5468-1 D5468-1
Inspection Dwg: D5468 Rev. A	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5468 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.438		0.438			
B	1.745	1.755		1.750		1.750			
C	3.495	3.505		3.500		3.500			
D	1.745	1.755		1.750		1.750			
E	7.990	8.010		7.995		7.997	7.998		
F	0.490	0.510		0.500		0.506			
G	0.257	0.262		0.258		0.258	0.258		
H	0.375	0.380		0.376		0.376	0.376		
I	0.490	0.510		0.502		0.5045	0.502		
J	1.174	1.184		1.179		1.179	1.179		
K	0.558	0.578		0.570		0.570	0.570		
L	1.174	1.184		1.179		1.179	1.179		
M	1.365	1.375		1.370		1.370	1.370		
N	2.495	2.505		2.500		2.500	2.500		
O	4.119	4.129		4.124		4.124	4.124		
P	0.115	0.135		0.130		0.130	0.130		
Q	0.115	0.135		0.125		0.125	0.125		
R	0.240	0.260		0.255		0.254	0.255		
S	0.115	0.135		0.131		0.130	0.133		
T	0.178	0.198		0.188		0.188	0.188		
U	3.210	3.250		3.230		3.236	3.230		
V	0.230	0.250		0.241		0.2395	0.240		
W	0.115	0.135		0.133		0.133	0.133		
X	0.352	0.372		0.366		0.366			
Y	0.470	0.530		0.500		0.500	0.500		
Z	0.615	0.635		0.604		0.607			
AA	0.053	0.073		0.068		0.063	0.058		
AB	0.240	0.260		0.255		0.255	0.256		
AC	1.500	1.520		1.510		1.510	1.510		
AD	0.115	0.135		0.122		0.122	0.122		
AE	0.240	0.280		0.255		0.260	0.260		
AF	0.240	0.260		0.253		0.258	0.256		
AG	2.000	2.020		2.000		2.000	2.000		
Accept/Reject				Scrap					

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 19/5/19	Date: 19/05/19

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 193 215
Description: Saddle, Aft Inboard	Part Number: D5469-4 D5468-1
Inspection Dwg: D5469 Rev. A	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 4	2 5	3 6	4 7		
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		7.999	7.999				
F	0.490	0.510		0.503	0.499				
G	0.257	0.262	✓	0.258	0.258				
H	0.375	0.380	✓	0.375	0.375				
I	0.490	0.510		0.5015	0.500				
J	1.174	1.184	✓	1.179	1.179				
K	0.558	0.578		0.568	0.569				
L	1.174	1.184	✓	1.179	1.179				
M	1.365	1.375	✓	1.370	1.370				
N	2.495	2.505	✓	2.500	2.500				
O	4.119	4.129	✓	4.124	4.124				
P	0.115	0.135		0.130	0.130				
Q	0.115	0.135	✓	0.125	0.125				
R	0.240	0.260	✓	0.254	0.255				
S	0.115	0.135		0.127	0.126				
T	0.178	0.198	✓	0.188	0.188				
U	3.210	3.250	✓	3.230	3.230				
V	0.230	0.250		0.241	0.240				
W	0.115	0.135		0.126	0.128				
X	0.352	0.372		0.367	0.3675				
Y	0.470	0.530	✓	0.500	0.500				
Z	0.615	0.635		0.626	0.627				
AA	0.053	0.073		0.062	0.065				
AB	0.240	0.260		0.255	0.255				
AC	1.500	1.520	✓	1.510	1.510				
AD	0.115	0.135		0.125	0.122				
AE	0.240	0.280	✓	0.260	0.260				
AF	0.240	0.260		0.258	0.259				
AG	2.000	2.020	✓	2.000	2.000				
Accept/Reject									

Measured by: <i>VH</i>
Date: 19/5/18

Audited by: <i>my</i>
Date: 19/05/19

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG <i>ml</i>	<i>A</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>193 215</u> Part No. <u>D5468-1</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																															
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Date : <u>19/05/17</u>		Step #: <u>100</u>		QTY Effective : <u>1</u>		MRB (QSI042) Approval <u>19-05-13</u>																																																																																																																																	
Description Work Order Deviation <u>Alarm 175 ground fault detected</u> <u>spidell fall into the piece</u>				Disposition <u>Scrap/destroyed</u>		Completed By <u>DAS 57</u> <u>9-89 19/05/17</u> Lead hand / Supervisor Approval Verification <u>19/05/21</u> QC / QA Coordinator Approval <u>19-05-17</u>																																																																																																																																	
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	FAULT CATEGORY <table style="width:100%;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☒</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☒</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>						Pressure/Forced	☐	Temperature/Cure	☒	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Cracks	☐	Broken/Damage/Defect	☒	Weld	☐	Part Incorrect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
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LOA	☐	Product Improvement	☐																																																																																																																																				
Substation	☐	Process Improvement	☐																																																																																																																																				
Past Expiry Date	☐	Manufacturing Process	☐																																																																																																																																				
Misidentified	☐	Past Due	☐																																																																																																																																				
Pressure/Forced	☐	Temperature/Cure	☒	Power Loss/Surge	☐	Positioned Wrong	☐																																																																																																																																
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐																																																																																																																																
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐																																																																																																																																
Cracks	☐	Broken/Damage/Defect	☒	Weld	☐	Part Incorrect	☐																																																																																																																																
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐																																																																																																																																
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐																																																																																																																																
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐																																																																																																																																
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																
OTHER : _____																																																																																																																																							